

Date: Tuesday, 16/12/2008 12:59:53 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CASTING, SUPPORT BRACKET		
Job Number	: 44114		Part Number	: D2265		
Estimate Number	: 10935		Drawing Number	: D2265 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 16/12/2008		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 16/12/2008		
Previous Run	: 37477		Qty:	100	Um:	Each
Written By	:		Comment	: Est D 98.12.15 Added Dwg Rev DM		
Checked & Approved By	: <u>Clo8112116</u>					
Comment						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O: <u>7632</u> <u>Clo8112116</u> Cast parts per drawing D2265 Possible Supplier: Alpine Foundry Material release note required
2.0	D2265P	Step Support Casting
		 Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s) Step Support Casting
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK <p><i>P. 08/12/15 100</i></p>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 Grind tips of castings as per Dwg D2265

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2265 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/12/18

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 44114		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.12.18	1	Supplier used 535.2 alloy Instead of 356.2	<i>CP</i> 08.12.18 per 081042	535.2 IS AN ACCEPTABLE SUBSTITUTE TO 356.2. PER BY ASTM B26 & B179, 535.2 HAS SUPERIOR STRENGTH. ACCEPTABLE. SEE ATTACHED	<i>A</i> 10/12/18	<i>S</i> 081219	<i>CP</i> 08.12.18 per 081042	<i>S</i> 081219

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CASTING, SUPPORT BRACKET

Job Number: 44114

Part Number: D2265

Job Number:

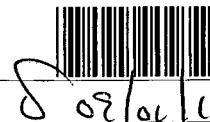


Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 425

9/1/15

SP

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/01/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09/01/15

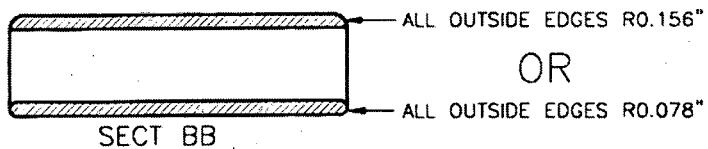
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

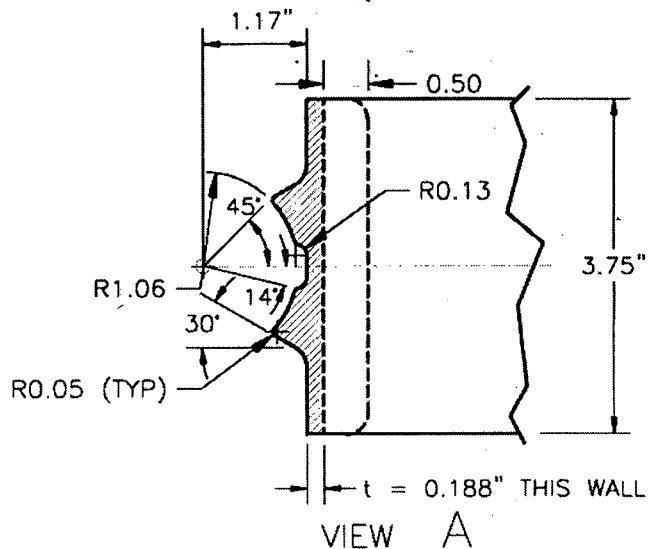
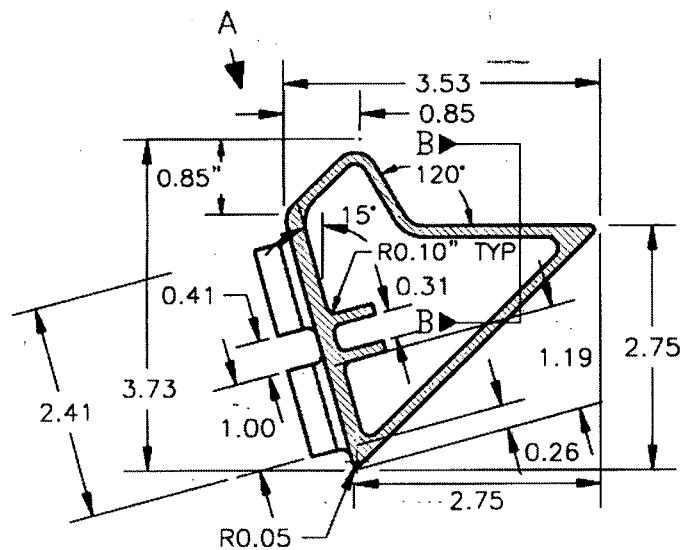
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



UNDIMENSIONED OUTER RADII 0.375"
UNDIMENSIONED INNER RADII 0.25"
UNDIMENSIONED WALL THICKNESSES 5/32"

MATERIAL: CAST ALUMINUM
ALLOY A356.2 (F)



RELEASED
96/05/27

DART

COPIES
MADE

PREPARED B. Williams	APPROVED X	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED		REV. A
		SHEET 1 OF 1
DATE Aug. 18, 1994	TITLE STEP SUPPORT CASTING	SCALE 1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ALPINE NON-FERROUS FOUNDRY
 8657-132ND STREET
 SURREY, B.C. V3W 4P1

Attn: Shantal
WORK ORDER

Tel: (604) 596-8080 Fax: (604) 596-8045

Sold To: DART AEROSPACE
 1270 ABERDEEN STREET
 HAWKESBURY, ONT K6A 1K7
 CANADA

Ship To: DART AEROSPACE

Order Date	Purchase Order#	Due Date	Ship Via	Page
20-Nov-2008	PO0007632		FEDEX	1
1	DART D2265 ✓ <i>Col8112116</i>	D2265 CSTG SUPPORT BRACKET	100	100
2				
Comments				
Castings&Patterns are property of Alpine until paid in full				
<i>Shipped by Fedex on Dec 11/08</i>				



ALPINE NON-FERROUS FOUNDRY OF CANADA LTD.
 8657-132nd Street, Surrey, B.C. V3W 4P1
 Bus: (604) 596-8080 Fax: (604) 596-8045
 E-mail: gdhiman@telus.net

INVOICE

Invoice No.: 3926
 Date: 16-Dec-2008
 Re. Order No.: PO0007632-2

Sold To:
 DART AEROSPACE
 1270 ABERDEEN STREET
 HAWKESBURY, ONT K6A 1K7
 CANADA

Ship To: DART AEROSPACE

Business No.: 875500001 RC0001

Item No.	Quantity	Unit	Description	Tax	Unit Price	Amount
DART D2265	100	Each	D2265 CSTG SUPPORT BRACKET	GS	13.75	1,375.00
Subtotal:						1,375.00
GS - GST @ 5%						
GST						68.75
PST Exempt						
Terms: Net 30						
Due 15-Jan-2009						

Shipped By FEDEX

Comments

Total Amount 1,443.75

CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS
 13329 ECTOR STREET CITY OF INDUSTRY, CA 91746
 PHR (626) 369-3641 FAX# (626) 369-2471

CUSTOMER:

RYPAC ALUMINUM
 11849 TANNERY ROAD
 SURREY BRITISH COLUMBIA,

SHIP DATE

NOV 05 2008

CONFORMS TO ASTM SPECIFICATION: B179-06

Alloy: 535.2

Heat: aB297

See Plot on Page #1

Si	0.075
Fe	0.087
Cu	0.005
Mn	0.173
Mg	7.380
Cr	0.001
Zn	0.050
Ti	0.146
Sn	0.004
Pb	0.001
Ni	0.001
OET	< .15
Sr	0.000
Al	REMAINDER

Si	.10
Fe	.10
Cu	.05
Mn	.10-.25
Mg	6.6-7.5
Cr	
Zn	.05
Ti	.10-.25
Sn	
Pb	
Ni	
OET	.15
Sr	
Al	REMAINDER

BE .004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.

Ron Zakerewski

RON ZAKRZEWSKI

LAB MANAGER

PM-1241 Rev-D 12/3/2001

NOV 05 2008

DATE

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.

Chris Provencal

From: Chris Provencal [cprovencal@dartaero.com]

Sent: December 18, 2008 4:04 PM

To: 'David Shepherd'

Cc: 'mpetsche@dartaero.com'

Subject: NCR D2265

Attachments: alum-casting-alloys_FEB05.pdf; B 26 – B 26M – 03 ;QJI2L0IYNK0_.pdf; B 179 – 03 ;QJE3OQ__.pdf; Matl-Cert.pdf; D2265-RevA.pdf

David,

We've received some D2265 Step Support Castings that use a different grade of aluminum than called on the dwg. The dwg is calling up aluminum alloy **A356.2 (F)** [which I assume refers to ANSI 356.2 (F), as A356.2 doesn't exist in the casting specs]. The supplied parts are **ANSI 535.2**, per ASTM B179-06.

Per ASTM B179, the difference between 356.2 and 535.2 is that 535.2 has less silicon and heavy metals [iron, copper, zinc], but more manganese and magnesium.

Looking at ASTM B26 (which ASTM B179 references), alloy 356.0 (F) has a Ftu = 19ksi, Fty = 9.5ksi, Min elong = 2.0, and brinell hardness of 55. 356.2 is a subset of 356.0, the ".2" meets the max composition requirements of the ".0", but not vice versa. So these strength requirements are applicable to 356.2 (F).

ASTM B26 indicates that 535.0 (F) has a Ftu = 35.0ksi, Fty = 18.0 ksi, min elong = 9.0 and brinell hardness of 70. Similarly, these strength properties would be applicable to 535.2 (F).

Therefore the supplied parts are stronger than the dwg requirements. I therefore think this is an acceptable substitution. The supplier indicated that they use 535.2 alloy because it doesn't require heat treating to have any strength. ASTM B26 substantiates this giving a series of tempers for 356.0 series alloy, but all have a Ftu less than 535.0 in the (F) "as cast" condition.

Further, doing some net searching I found the attached pdf from "Mid-Atlantic Casting Services", which indicates that 535.0 is known for having good strength, shock resistance, ductility, and very high corrosion resistance (because of a lack of heavy metals). Further the high magnesium is said to give it excellent resistance to salt spray. Although not a controlled doc, this would further allude to the fact 535.0 is superior.

Unless otherwise indicated, I will sign-off the material as an acceptable deviation on the dwg based on the superior strength properties of the 535.2 aluminum. I will update the dwg to add this alloy as an option, and to add reference to ASTM B179. I will add this email to a design review justifying the change. I've attached the relevant reference docs in case you want to review this yourself.

Sincerely,
Christopher Provencal
DART Aerospace Ltd.

cprovencal@dartaero.com
Tel: (613) 632 5200
Fax: (613) 632 9311

TABLE 1 Chemical Composition Limits for Alloys Normally Used in Sand and Permanent Mold Casting Processes

NOTE 1—Where single units are shown, these indicate the maximum amounts permitted.

NOTE 2—Analysis shall be made for the elements for which limits are shown in this table.

NOTE 3—The following applies to all specified limits in this table: For purposes of determining conformance to these limits, an observed value or a calculated value obtained from analysis shall be rounded to the nearest unit in the last right-hand place of figures used in expressing the specified limit in accordance with the rounding-off method of Practice E 29.

Alloy ^A		Use ^B	Composition, %										Others ^C	Aluminum	
ANSI ^A	UNS		Silicon	Iron	Copper	Manganese	Magnesium	Chromium	Nickel	Zinc	Tin	Titanium	Each	Total ^D	
201.2	A02012	S	0.10	0.10	4.0-5.2	0.20-0.50	0.20-0.55	0.15-0.35	0.05 ^E	0.10	remainder
204.2	A02042	S,P	0.15	0.10-0.20	4.2-4.9	0.05	0.20-0.35	...	0.03	0.05	0.05	0.15-0.25	0.05	0.15	remainder
242.1	A02421	S,P	0.7	0.8	3.5-4.5	0.35	1.3-1.8	0.25	1.7-2.3	0.35	...	0.25	0.05	0.15	remainder
242.2	A02422	S,P	0.6	0.6	3.5-4.5	0.10	1.3-1.8	...	1.7-2.3	0.10	...	0.20	0.05	0.15	remainder
A242.1	A12421	S	0.6	0.6	3.7-4.5	0.10	1.3-1.7	0.15-0.25	1.8-2.3	0.10	...	0.07-0.20	0.05	0.15	remainder
A242.2	A12422	S	0.35	0.6	3.7-4.5	0.10	1.3-1.7	0.15-0.25	1.8-2.3	0.10	...	0.07-0.20	0.05	0.15	remainder
295.1	A02951	S	0.7-1.5	0.8	4.0-5.0	0.35	0.03	0.35	...	0.25	0.05	0.15	remainder
295.2	A02952	S	0.7-1.2	0.8	4.0-5.0	0.30	0.03	0.30	...	0.20	0.05	0.15	remainder
296.1	...	P	2.0-3.0	0.9	4.0-5.0	0.35	0.05	...	0.35	0.50	...	0.25	0.35	0.15	remainder
296.2	...	P	2.0-3.0	0.8	4.0-5.0	0.30	0.03	0.30	...	0.20	0.05	0.15	remainder
308.1	A03081	P	5.0-6.0	0.8	4.0-5.0	0.50	0.10	1.0	...	0.25	...	0.50	remainder
308.2	A03082	P	5.0-6.0	0.8	4.0-5.0	0.30	0.10	0.50	...	0.20	...	0.50	remainder
319.1	A03191	S,P	5.5-6.5	0.8	3.0-4.0	0.50	0.10	...	0.35	1.0	...	0.25	...	0.50	remainder
319.2	A03192	S,P	5.5-6.5	0.6	3.0-4.0	0.10	0.10	...	0.10	0.10	...	0.20	...	0.50	remainder
328.1	A03281	S	7.5-8.5	0.8	1.0-2.0	0.20-0.6	0.25-0.6	0.35	0.25	1.5	...	0.25	...	0.20	remainder
332.1 ^F	A03321	P	8.5-10.5	0.9	2.0-4.0	0.50	0.6-1.5	...	0.50	1.0	...	0.25	...	0.50	remainder
332.2 ^F	A03322	P	8.5-10.0	0.6	2.0-4.0	0.10	0.9-1.3	...	0.10	0.10	...	0.20	...	0.50	remainder
333.1	A03331	P	8.0-10.0	0.8	3.0-4.0	0.50	0.10-0.50	...	0.50	1.0	...	0.20	...	0.50	remainder
336.1 ^F	A03361	P	11.0-13.0	0.9	0.50-1.5	0.35	0.8-1.3	...	2.0-3.0	0.35	...	0.25	...	0.50	remainder
336.2 ^F	A03362	P	11.0-13.0	0.9	0.50-1.5	0.10	0.9-1.3	...	2.0-3.0	0.10	0.30	remainder
354.1	A03541	P	8.6-9.4	0.15	1.6-2.0	0.10	0.45-0.6	0.10	...	0.20	0.05	0.15	remainder
355.1	A03551	S,P	4.5-5.5	0.50 ^G	1.0-1.5	0.50 ^G	0.45-0.6	0.25	...	0.35	...	0.25	0.05	0.15	remainder
355.2	A03552	S,P	4.5-5.5	0.14-0.25	1.0-1.5	0.05	0.50-0.6	0.05	...	0.20	0.05	0.15	remainder
C355.2	A33552	S,P	4.5-5.5	0.13	1.0-1.5	0.05	0.50-0.6	0.05	...	0.20	0.05	0.15	remainder
356.1	A03561	S,P	6.5-7.5	0.50 ^G	0.25	0.35 ^G	0.25-0.45	0.35	...	0.25	0.05	0.15	remainder
356.2	A03562	S,P	6.5-7.5	0.13-0.25	0.10	0.05	0.30-0.45	0.05	...	0.20	0.05	0.15	remainder
A356.2	A13562	S,P	6.5-7.5	0.12	0.10	0.05	0.30-0.45	0.05	...	0.20	0.05	0.15	remainder
357.1	A03571	P	6.5-7.5	0.12	0.05	0.03	0.45-0.6	0.05	...	0.20	0.05	0.15	remainder
A357.2	A13570	P	6.5-7.5	0.12	0.10	0.05	0.45-0.7	0.05	...	0.20	0.05	0.15	remainder
359.2	A03592	P	8.5-9.5	0.12	0.10	0.10	0.55-0.7	0.10	...	0.04-0.20	0.03 ^H	0.10	remainder
443.1	A04431	S,P	4.5-6.0	0.6	0.6	0.50	0.05	0.25	...	0.50	...	0.20	0.05	0.15	remainder
443.2	A04432	S,P	4.5-6.0	0.6	0.10	0.10	0.05	...	0.10	...	0.20	...	0.35	0.15	remainder
B443.1	A24431	S,P	4.5-6.0	0.6	0.15	0.35	0.05	...	0.35	...	0.20	...	0.05	0.15	remainder
A444.2	A14442	P	6.5-7.5	0.12	0.05	0.05	0.05	0.05	...	0.25	0.05	0.15	remainder
513.2 ^F	A05132	P	0.30	0.30	0.10	0.10	3.6-4.5	0.05	...	0.20	0.05	0.15	remainder
514.1	A05141	S	0.35	0.40	0.15	0.35	3.6-4.5	1.4-2.2	...	0.20	0.05	0.15	remainder
514.2	A05142	S	0.30	0.30	0.10	0.10	3.6-4.5	0.15	...	0.25	0.05	0.15	remainder
520.2	A05202	S	0.15	0.20	0.20	0.10	9.6-10.6	0.10	...	0.20	0.05	0.15	remainder
535.2	A05352	S,P	0.10	0.10	0.05	0.10-0.25	6.6-7.5	0.10	...	0.20	0.05	0.15	remainder
705.1	A07051	S,P	0.20	0.6	0.20	0.40-0.6	1.5-1.8	0.20-0.40	...	2.7-3.3	...	0.10-0.25	0.05 ^I	0.15	remainder
707.1	A07071	S,P	0.20	0.6	0.20	0.40-0.6	1.9-2.4	0.20-0.40	...	4.0-4.5	...	0.25	0.05	0.15	remainder
710.1 ^F	A07101	S	0.15	0.40	0.35-0.65	0.05	0.65-0.8	6.0-7.0	...	0.25	0.05	0.15	remainder
711.1 ^F	A07111	P	0.30	0.7-1.1	0.35-0.65	0.05	0.30-0.45	6.0-7.0	...	0.20	0.05	0.15	remainder
712.2 ^F	A07122	S	0.15	0.40	0.25	0.10	0.50-0.65	0.40-0.6	...	5.0-6.5	...	0.15-0.25	0.05	0.20	remainder
713.1	A07131	S,P	0.25	0.8	0.40-1.0	0.6	0.25-0.50	0.35	0.15	7.0-8.0	...	0.25	0.10	0.25	remainder
771.2	A07712	S	0.10	0.10	0.10	0.10	0.85-1.0	0.06-0.20	...	6.5-7.5	...	0.10-0.20	0.05	0.15	remainder
850.1	A08501	S,P	0.7	0.50	0.7-1.3	0.10	0.10	...	0.7-1.3	...	5.5-7.0	0.20	...	0.30	remainder
851.1 ^F	A08511	S,P	2.0-3.0	0.50	0.7-1.3	0.10	0.10	...	0.30-0.7	...	5.5-7.0	0.20	...	0.30	remainder

TABLE 2 Tensile Requirements^A (Inch-Pound Units)

NOTE 1—For purposes of determining conformance with this specification, each value for tensile strength and yield strength shall be rounded to the nearest 0.1 ksi and each value for elongation shall be rounded to the nearest 0.5 %, both in accordance with the rounding method of Practice E 29.

Alloy		Temper ^B	Tensile Strength, min, ksi	Yield Strength (0.2 % offset), min, ksi	Elongation in 2 in. or 4 x diameter, min, %	Typical Brinell Hard- ness, ^C 500 kgf, 10 mm
ANSI ^D	UNS					
201.0	A02010	T7	60.0	50.0	3.0	...
204.0	A02040	T4	45.0	28.0	6.0	...
242.0	A02420	O ^E	23.0	F	F	70
		T61	32.0	20.0	F	
A242.0	A12420	T75	29.0	F	1.0	105
295.0	A02950	T4	29.0	13.0	6.0	60
		T6	32.0	20.0	3.0	75
		T62	36.0	28.0	F	95
		T7	29.0	16.0	3.0	70
319.0	A03190	F	23.0	13.0	1.5	70
		T5	25.0	F	F	80
		T6	31.0	20.0	1.5	
328.0	A03280	F	25.0	14.0	1.0	60
		T6	34.0	21.0	1.0	80
355.0	A03550	T6	32.0	20.0	2.0	80
		T51	25.0	18.0	F	65
		T71	30.0	22.0	F	75
C355.0	A33550	T6	36.0	25.0	2.5	...
356.0	A03560	F	19.0	9.5	2.0	55
		T6	30.0	20.0	3.0	70
		T7	31.0	F	F	75
		T51	23.0	16.0	F	60
		T71	25.0	18.0	3.0	60
A356.0	A13560	T6	34.0	24.0	3.5	80
		T61	35.0	26.0	1.0	
443.0	A04430	F	17.0	7.0	3.0	40
B443.0	A24430	F	17.0	6.0	3.0	40
512.0	A05120	F	17.0	10.0	...	50
514.0	A05140	F	22.0	9.0	6.0	50
520.0	A05200	T4	42.0	22.0	12.0	75
535.0	A05350	F	35.0	18.0	9.0	70
705.0	A07050	T5	30.0	17.0 ^G	5.0	65
707.0	A07070	T7	37.0	30.0 ^G	1.0	80
710.0 ^H	A07100	T5	32.0	20.0	2.0	75
712.0 ^H	A07120	T5	34.0	25.0 ^G	4.0	75
713.0	A07130	T5	32.0	22.0	3.0	75
771.0	A07710	T5	42.0	38.0	1.5	100
		T51	32.0	27.0	3.0	85
		T52	36.0	30.0	1.5	85
		T6	42.0	35.0	5.0	90
		T71	48.0	45.0	2.0	120
850.0	A08500	T5	16.0	F	5.0	45
851.0 ^H	A08510	T5	17.0	F	3.0	45
852.0 ^H	A08520	T5	24.0	18.0	F	60

^A If agreed upon between the manufacturer and the purchaser, other mechanical properties may be obtained by other heat treatments such as annealing, aging, or stress relieving.

^B Refer to ANSI H35.1 and/or H35.1M for description of tempers.

^C For information only, not required for acceptance.

^D ASTM alloy designations are recorded in Practice B 275.

^E Formerly designated as 222.0-T2 and 242.0-T21.

^F Not required.

^G Yield strength to be determined only when specified in the contract or purchase order.

^H 710.0 formerly A712.0, 712.0 formerly D712.0, 851.0 formerly A850.0, 852.0 formerly B850.0.

4.2.5 Whether inspection is required at the producer's works (Section 20).

4.2.6 Whether certification is required (23.1).

4.2.7 Whether surface requirements shall be checked against observational standards where such standards are established (21.1).

4.2.8 Whether liquid penetrant inspection is required (21.2).

4.2.9 Whether radiographic inspection is required (21.3), and

4.2.10 Whether foundry control is required (Section 11).

4.2.11 Whether Practice B 660 applies and, if so, the levels of preservation, packaging and packing required (25.4).

5. Quality Assurance

5.1 Unless otherwise specified in the contract or purchase order, the producer shall be responsible for the performance of all inspections and test requirements specified herein. Unless disapproved by the purchaser, the producer may use his own or any other suitable facilities for the performance of the inspection and test requirements specified herein. The purchaser shall have the right to perform any of the inspections and tests set forth in this specification where such inspections are deemed necessary to confirm that the material conforms to prescribed requirements.